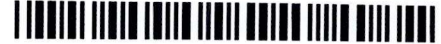




Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4504-1**Job Sheet 192036****Part No:** D4504-1**Job Qty:** 1 pcs**Part Name:** Half Height Bubble Window, LH**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 3/14/19**Job Tracking No:****Due Date:** 4/25/19**Created By:** Patrick Lussier**Type:** Stock**Description:****Note:** D4504 REV.A IPP Rev. A New Issue 12/02/16 DL**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	1 pcs	4/25/19	4/25/19	0.00	0.00	Purchasing - 1		MAY 28 2019
							Purchasing - 2		
							Purchasing - 3		
110	Packaging 2-1 - Receive - B4B	1 pcs	4/25/19	4/25/19	0.00	0.00	Packaging 2 - 1 - B4B		MAY 28 2019
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		
							Packaging 2 - 19 - B4B		
							Packaging 2 - 20 - B4B		
							Packaging 2 - 21 - B4B		
							Packaging 2 - 22 - B4B		
							Packaging 2 - 23 - B4B		
							Packaging 2 - 24 - B4B		
							Packaging 2 - 25 - B4B		
							Packaging 2 - 26 - B4B		
							Packaging 2 - 27 - B4B		
							Packaging 2 - 28 - B4B		



Dart Aerospace Ltd.
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CANADA
TEL : 1 613 632 - 5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S184504**Part:** D4504-1**Job No:** 192036**Serial No/Batch:** S184504**Revision:** A**Inspector:****Exp Date:****Instructions:** Various STC's**Date:** 05/28/19

Plex 3/14/19 1:26 PM dart.Lussier.Patrick

				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
120 QC 6	1 pcs	4/25/19	0.00 0.00	QC 6 - 42	
				QC 6 - 9	
				QC 6 - 68	
				QC 6 - 61	
130 Packaging 3-1 - Stock - B4B	1 pcs	4/25/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - SA	1 pcs	4/25/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 100 - ISSUE P/O: MANUFACTURE AS PER DWG D4504 C OF C IS REQUIRED ***EXTREME CARE MUST BE TAKING WHEN PACKAGING AND SHIPPING THIS PRODUCT.***

110 - ***EXTREME CARE MUST BE TAKING WHEN PACKAGING AND SHIPPING THIS PRODUCT.***

130 - ***EXTREME CARE MUST BE TAKING WHEN PACKAGING AND SHIPPING THIS PRODUCT.***

042094 x1 Plus 14 March 2019

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D4504-1P	Half Height Bubble Window, LH	1 Ea (1 ea)	100-Purchasing	5184436
MACRLICS.236	Plexiglass G 0.236"	13.7500 sf (13.75 ea) 128 sf	100-Purchasing	5152010
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	D4504-1P	1	0	0
	MACRLICS.236	14	288	0
Part Specifications				
Specifications could not be found.				

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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO042894**



Supplier: PLA002-VC
Plas-Tech
115 Applewood Crescent
Concord
ON
L4K 5C1 Canada
Phone: 416-736-0004
Fax: 416-736-0010

PO No: PO042894
PO Date: 3/14/19
Due Date: 5/23/19

Purchase Order
Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

Revision

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	192036	D4504-1P			Half Height Bubble Window, LH : Various STC's	Firmed	-	5/27/19	1 Ea	0 Ea	1 Ea	\$600.00/Ea	\$600.00
						<i>XI</i>		<i>MAY 27 2019</i>				<i>DP</i>	
2	192037	D4504-1P			Half Height Bubble Window, LH : Various STC's	Firmed	-	6/10/19	1 Ea	0 Ea	1 Ea	\$395.00/Ea	\$395.00
						<i>IX</i>		<i>MAY 28 2019</i>					
Grand Total:													\$995.00

Order Notes

Procurement Quality Clauses

A005 RIGHT OF ENTRY

A008 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION SENT TO DART AEROSPACE)

A012 CHEMICAL AND PHYSICAL TEST REPORTS

A016 PERSONNEL QUALIFICATION

A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)

A026 CERTIFICATION OF MATERIAL CONFORMANCE

A041 QUALITY MANAGEMENT SYSTEM

A042 DART NOTIFICATION BY SUPPLIER

A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 5/27/19 2:59 PM dart.Lussier.Patrick



115 Applewood Crescent
Concord, ON, L4K 5C1
PLASTECHONLINE.COM
P- 416 736 0004
F- 416 736 0010

Shipment Number: 35833
Shipment Date: 05/23/2019
BOL Number:
Customer Key: C1887
Salesperson: MIKE AUBE
Page Number: 1 of 1

Packing Slip

B DART AEROSPACE LTD.
I 1270 ABERDEEN STREET
L HAWKESBURY ON K6A 1K7
L CA
T Attn: DALE BATES
O Buyer Contact: PATRICK LUSSIER

S DART AEROSPACE
H 1270 ABERDEEN STREET
I HAWKESBURY ON K6A 1K7
P CA
T Attn: PATRICK LUSSIER
O

RECEIVED

MAY 27 2019

DART AEROSPACE LTD.

Purchase Order
42894

Sales Order
SO-028592

Incoterms
EX WORKS

Payment Method
COL

Carrier Account #
CU103666

Ship Via
JOURNEY FREIGHT -

Tracking Number

Item Number
Revision

Description

Quantity
Shipped UOM

D4504-1P - Rev.: A

HALF HEIGHT BUBBLE WINDOW

1 EA

AS PER DWG D4504 REV A

D4504-1P - Rev.: A

HALF HEIGHT BUBBLE WINDOW

1 EA

AS PER DWG D4504 REV A

Number of Containers

Gross Weight

Shipped By

Certificate Of Conformance



Customer: DART AEROSPACE LTD

P.O. # 42894

SO # 028592

Part #	D4504-1P	Qty.	1	Batch #	-001
Description	HALF HEIGHT BUBBLE WINDOW	Material usage	120 SQ.FT.	Lot#	DART0118 S152010
Part #	D4504-1P	Qty.	1	Batch #	-002
Description	HALF HEIGHT BUBBLE WINDOW	Material usage	120 SQ.FT.	Lot#	DART0118 S152010
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	

Note: All parts are not identified as meeting QSI044.

By: AS

(Approved QA Signatory)

Date: MAY 24, 2019

C OF C # 117

Page: 1 of 1

Plas-Tech Inc. 115 Applewood Cres. Concord, Ontario L4K 5C1 Tel: (416) 736-0004 Fax: (416) 736-0010

Email: info@plastechnonline.com, Web: www.plastechnonline.com

Certificate Of Conformance



Customer: DART AEROSPACE LTD

P.O. #

42894 ✓

SO #

028592

Part #	D4504-1P ✓	Qty.	1	Batch #	-001
Description	HALF HEIGHT BUBBLE WINDOW	Material usage	120 SQ.FT.	Lot#	DART0118 S152010
Part #	D4504-1P ✓	Qty.	1	Batch #	-002
Description	HALF HEIGHT BUBBLE WINDOW	Material usage	120 SQ.FT.	Lot#	DART0118 S152010
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	

Note: All parts are not identified as meeting QSI044.

By:

(Approved QA Signatory)

Date:

MAY 24, 2019

C OF C #

117

Page:

1 of 1

Plas-Tech Inc. 115 Applewood Cres. Concord, Ontario L4K 5C1 Tel: (416) 736-0004 Fax: (416) 736-0010

Email: info@plasteconline.com, Web: www.plasteconline.com

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

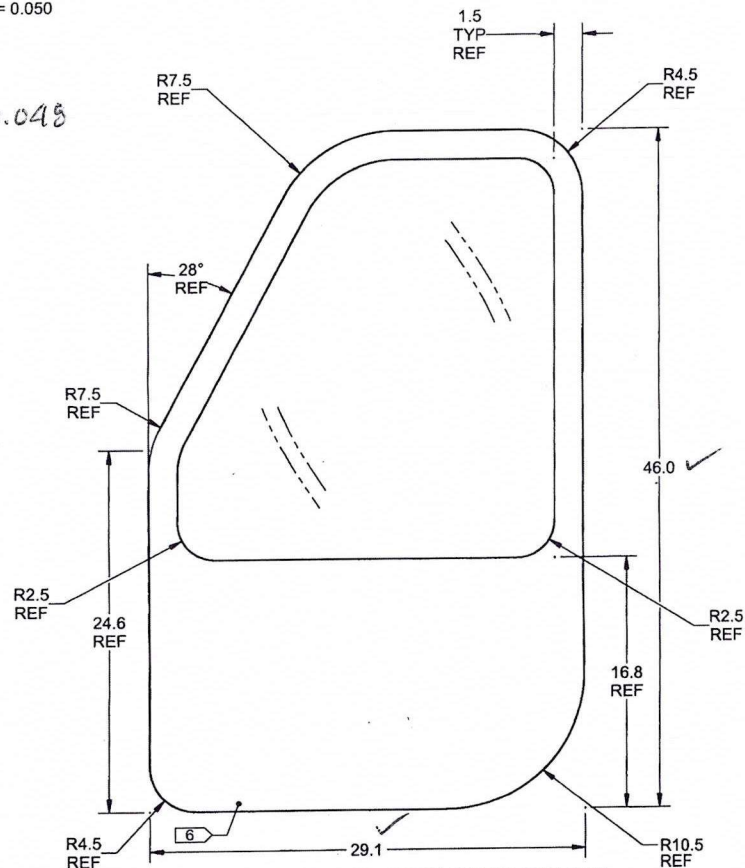
Route update only ☐

Job: <u>192037/192036</u> Part No. <u>D4504-1</u>	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☒		
Date: <u>MAY 28 2019</u>	Sequence #: <u>120 QCG</u>	QTY Affected: <u>1+1 (2PCS)</u>	MRB (QSI042) <u>INSP 12 4/15/20</u>	
Description Work Order Deviation - DRAWING SPECIFIES MIN. THK. OF 0.050" FOR OUTER 7.2", - ACTUAL FOR OUTER 5" IS 0.031" - 0.045" DAS 68 9-89		Disposition <u>Approx 14" sq. area under tolerance by up to 0.015". Rejected.</u>		Completed By Lead hand / Supervisor QC / QA Coordinator
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		
MEASURED BY ULTRASOUND		Other/Details:		

0.102
 3.0
 MIN THICKNESS = 0.070
 5.0
 MIN THICKNESS = 0.090
 0.236
 REF

MAX DEPTH = 15.0 ± 0.5 $15\frac{3}{16}$
 7.2
 MIN THICKNESS = 0.050

0.031-0.0048



D4504-1 HALF HEIGHT BUBBLE WINDOW (LH)

NOTES:

- 1) MATERIAL: PLEXIGLASS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C OR POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425, 0.236 THICK (REF. DART SPEC. M-ACRYLIC-S.236)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: ENGRAVE P/N "D4504-1" & B/N "BXXXXX" ON THE INSIDE SURFACE WITHIN 0.50" OF BOTTOM EDGE. USE 0.125" LETTERS TO MAX. DEPTH OF 0.005" PER QSI 044 6.4 WITH VIBRATING STYLUS
- 7) WEIGHT: 11.0 lbs
- 8) THERMOFORM PER DART QSI 022 USING DT8992 & DT9795

DESIGN	RP
DRAWN	RP
CHECKED	<i>[Signature]</i>
MFG. APPR.	<i>[Signature]</i>
APPROVED	<i>[Signature]</i>
DE APPR.	<i>[Signature]</i>
DATE	12.03.01

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4504	REV. A SHEET 2 OF 3
TITLE HALF HEIGHT BUBBLE WINDOW	SCALE NTS
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 2012-03-08
[Signature]